



Dart Aerospace Ltd.
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D4170-1
Job Sheet 186816



Part No: D4170-1

Job Qty: 40 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per revB DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Machining-2	1/18 JSD 18/12/18	
100	Hardinge	40 pcs	12/7/18	12/7/18	0.00	1.15	Hardinge	" "	
120	QC	40 pcs	12/7/18	12/7/18	0.00	0.00	QC8	18/12/19	
125	Skidtubes	40 pcs	12/7/18	12/7/18	0.00	0.59	Skidtubes-2	DE	
130	Packaging	40 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	DGE	
140	QC21-SA	40 Ea	12/7/18	12/7/18	0.00	0.00	QC21	21	

Part Op 100 - Machine as per Fqlio FA962

Descriptions: 125 - 1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130 - ***STOCK IN SKIDTUBE CELL***

DEC 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.375W.058	6061-T6 Round Tube .375 X.058W	10.6640 ft (.2666 ea)	90-Start up Operation	5092703

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.375W.058	11	271	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	3.150Inches	+ 0.030 - 0.000	3.180 3.150	
2	Spacer	0.375Inches	± 0.010	0.385 0.365	Diameter
3	Spacer	0.259Inches	± 0.010	0.269 0.249	Diameter

Plex 11/21/18 2:10 PM dart.white.jesse

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																	
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Date : _____		Step #: _____		MRB (QSI042) Approval																																																	
Description Work Order Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																					
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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Container No: S137508



Part: D4170-1

Job No: 186816

Serial No/Batch: S137508

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/12/18

OTHER :